

REFERENCE ONLY

NEW STATUS OF SHEETS	REV	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44
SHEET		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
1	MTG. RELEASE	10/12/95	WJ
2	CHANGES TO IMPROVE FUNCTIONALITY	5/7/96	WJ
3	UNG AND P/L REVISED AND UPDATED	6/15/96	WJ
4	TO REFLECT BELI MODIFICATIONS		
5	CHANGED Design/ Approv First	6/5/96	

1. IDENTIFY PART PER PREMIER IDENTIFICATION AND MARKING PROCEDURES 115-1712 LOCATION, CHARACTER HEIGHT, AND PROCESS AS REQUIRED. MARK IN CONTRASTING COLOR.
2. FOR SHEET METAL PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .01-.03, EXCEPT AS NOTED. FOR MACHINED PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .015 MAX, EXCEPT AS NOTED.
3. GENERAL SHOP PRACTICES (A.W. PREMIER SPEC. DOB-93000 AND AC43.13).
4. OPEN
5. WELD PARTS PER MIL-2219, CLASS II.
6. CHW FLOW (ALODINE) ALL ALUMINUM DETAIL PARTS PER PREMIER SPEC DOB-93063, CLASS 1A, AND PRIME WITH EPOXY PRIMER PER MIL-P-23377C, ZINC CHROMATE PRIMER PER MIL-ITP-1757, OR EQUIVALENT.
7. STITCHING PER FED-STD-751.

21. SECURE -43 BELT ASSY TO TOP GT -65 (OF -65) OR -47 (OF -67).
LOCATE APPROX AS SHOWN.
22. WITH -137 SCREW IN OPEN POSITION, LOCATE RIVET
APPROX AS SHOWN, TO SERVE AS A STOP FOR -137
23. DRILL WITH -37 AT VERTICAL FULL OPEN POSITION.
DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION.
ASSURING -37 CLEARS ADJACENT STRUCTURE.
24. SHIM AS REQD. USING NAS1149033PJ WASHERS.
25. -81 FWD BLADEFOLD ASSY FOR COMMERCIAL VERSIONS ONLY
-82 FWD BLADEFOLD ASSY FOR CANADIAN VERSIONS ONLY
26. TOLERANCE ON DECIMAL $\pm .1$
27. LAST SERIAL LETTER USED "I"
28. DRILL NO. 30 (65.126) HOLE THRU -37 AND -25 (COMPONENT
-25) ASSY, INSERT 803074 SET PIN, AND GRIND FLOSH
WITH -37

- WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS MOST EXTENDED POSITION 11-HANDLE LOCKED ON LOWEST HOOK). DRILL A .25 DIA HOLE THROUGH THE OUTER TUBE .35 BELOW THE BOTTOM OF THE INNER TUBE AND INWARD FROM THE OUTER SIDE OF THE OUTER TUBE. UNLOCK THE INNER TUBE CRADLE ASSEMBLY AND MOVE IT TO ITS LOWEST, MOST RECESSED POSITION. MATCH DRILL THE INNER TUBE TO THE HOLE JUST DRILLED IN THE OUTER TUBE. .25 DIA.
- ▲ INSTALL TFFLOW TUBE BUSHING INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT 803073 SET P.W. AND GRIND FL. USER TO CONTOUR OF OUTER TUBE. 6 PL 12 PL EA BUSHING!
- ▲ GRIND BUSHING AND WELD TO CONTOUR OF TUBE.
- ▲ ALIGN CRADLE ASSEMBLY 90 DEGREES FROM THE CENTERLINE AXIS OF THE BUSHING OR THE OTHER END OF THE TUBE. WELD GUSSET ON CENTER WITH TUBE AND BOTTOM OF CRADLE ASSEMBLY.
- ▲ CHAMFER EDGE FOR BETTER WELDING.
- ▲ TAP HOLE TO 1/4-20 THRU.
- ▲ INSTALL CL-40-SBP-3 DEFENT BALL INTO HOLDING FIXTURE SO THAT THE BALL IS POSITIONED SLIGHTLY ABOVE FLUSH WITH THE TUBE SEAT SURFACE. ALIGN THE TUBE IN THE FIXTURE AND MARK THE BALL CONTACT LOCATION ON THE TUBE. USE A SMALL PUNCH TO DIMPLE THE TUBE AT THE MARKED LOCATION. INSERT THE TUBE BACK INTO THE FIXTURE AND ADJUST FOR PROPER SIGHTING.
- 15. PERMISSIBLE TO SUBSTITUTE EQUIVALENT AN660 WASHER FOR NAS1619 WASHER UNTIL CURRENT STOCK IS DEPLETED.
- 16. PAINT ALL ASSEMBLIES AND WELDMENTS AS REQUIRED, EXCEPT WHERE NOTED. 2368JU W ORGA YELLOW. PER FED-STD-525.
- ▲ NO PAINT REQUIRED, CHEM FILM ONLY WHERE APPLICABLE. PLR PREMIER SPEC 908-93003.
- ▲ STITCH APPROX AS SHOWN, PER FED-STD-751.
- ▲ PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH TRIMMER NAS1659 EQUIVALENT.
- ▲ DISASSEMBLE -53 HANDLE ASSY (BOTH SIDES) PRIOR TO INSTALLATION AND REMOVAL OF -01 OR -57 BLAUFDOLF ASSY TO AIRCRAFT

RELEASE
71 06 01 20

ECO
5007
5161
6262

REFERENCE ONLY

SEE SEPARATE PARTS LIST B67-4300IPL

[illegible]

ORIGINAL

Date: Tuesday, 23/09/2008 9:51:53 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 41290

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

30345T24

LANYARDS



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

LANYARDS

batch: M108973

MF 08-10-24

42.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

SPRING SLOTTED PIN

batch: M17850

MF 08-10-24

43.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: M109687

Cpl 08.10.24

SAP 08.10.24

M.F.

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/24 (x2)

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPD B4/180 B4/181

Cpl 24/2

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2
08/10/24

Job Completion



MF 08-10-24

Date: Tuesday, 23/09/2008 9:51:53 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 41290

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

~~AN629A~~

Bolt



AN6C16A *epc*



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch: ~~m104547~~ m105831

mf 08-10-24

35.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

batch: m18180

mf 08-10-24

36.0

BSP43

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

RIVET

batch: m109119 x 10, ~~m10911~~ m17890 x 6

mf 08-10-24

37.0

CR3213405

cherry rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

cherry rivet

batch: m104214

mf 08-10-24

38.0

~~MS17984C408~~

PIN, QUICK RELEASE



MS17984C-410 *epc*



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

PIN, QUICK RELEASE

batch: ~~m108986~~ m18118

mf 08-10-24

39.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

PIN, QUICK RELEASE

batch: m108991 x 4, m108986 x 4

mf 08-10-24

40.0

30345T22

8" LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

8" LANYARD

batch: m108390

mf 08-10-24

Date: Tuesday, 23/09/2008 9:51:52 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 41290

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

NAS1149F0632P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

batch: 108057

MF 08-10-24

28.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: 18057

MF 08-10-24

29.0

AN960JD6

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: 4085

MF 08-10-24

30.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: m103962 x4, m101291 x4

MF 08-10-24

31.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: m107959

MF 08-10-24

32.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

batch: 19278

MF 08-10-24

33.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch: m105558

MF 08-10-24

Date: Tuesday, 23/09/2008 9:51:52 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 41290

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut

batch: M107499

UMF 08-10-24

21.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

batch: M105077

UMF 08-10-24

22.0

MS518596

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

batch: M108413

UMF 08-10-24

23.0

~~MS518596~~

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

batch: M108986

106421

UMF 08-10-24

24.0

NAS43DD368

SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

SPACER

batch: M108473 X 6

UMF 08-10-24

25.0

NAS1149F0316P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: M108473

UMF 08-10-24

26.0

NAS1149F0432P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

batch: 10818057

UMF 08-10-24

Date: Tuesday, 23/09/2008 9:51:52 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 41290

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D34473

Square Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Square Spacer

batch: B 24416 x 6, B 41351 x 2

CMF 08-10-24

14.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Swing Arm

batch: B 41278 x 8

CMF 08-10-24

15.0

D3445041

Belt Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Belt Assembly

batch: B 39966 x 2

CMF 08-10-24

16.0

086004

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Inventory

batch: m17850 x 8

CMF 08-10-24

17.0

MS27039104

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Inventory

batch: B 18431

CMF 08-10-24

18.0

MS27039123

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

SCREW

batch: 18057

CMF 08-10-24

19.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Nut

batch: 108701

CMF 08-10-24

User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 41290

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB674300145

Longitudinal Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Longitudinal Support Assembly

batch: 41013

MF 08-10-21

7.0

PB674300151

Long T-Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Long T-Handle Assembly

batch: 41381

MF 08-10-21

8.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Lever Arm

batch: B41294

MF 08-10-21

9.0

PB6743001265

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bushing

batch: ~~B40056~~ B.41373

MF 08-09-23

10.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bushing

batch: B40062

MF 08-09-23

11.0

D3451048

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Handle and Lock-Down Assembly

batch: ~~B41064~~ X2, B42286

MF 08-10-24

12.0

D3451047

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Handle and Lock-Down Assembly

batch: ~~B41063~~ X2, ~~B41279~~ X2

MF 08-10-24.

NOT in comp.

Date: Tuesday, 23/09/2008 9:51:52 AM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD BLADE FOLD ASSEMBLY
Job Number	: 41290-1		
Estimate Number	: 13531		
P.O. Number	:	Part Number	: PB674300101
This Issue	: 23/09/2008 S.O. No. :	Drawing Number	: B6743001 P.1, 2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 18/08/2008 Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 41237	Material	:
Written By	:	Due Date	: 15/09/2008 Qty: <i>split 2</i> Um: Each
Checked & Approved By	: <i>mf 08-09-23</i>		
Comment	: Est Rev:A 08-07-30 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB674300107	Fwd Blade Fold Assembly Weldment
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Fwd Blade Fold Assembly Weldment batch: <i>4136 x 2</i> <i>mf 08-10-24</i>		
2.0	PB674300115	Fwf Adjustable Blade Support Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Fwf Adjustable Blade Support Assembly batch: <i>640608 x 2</i> <i>mf 08-10-24</i>		
3.0	PB674300111	Fwf Adjustable Blade Support Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Fwf Adjustable Blade Support Assembly batch: <i>40606</i> <i>mf 08-10-24</i>		
4.0	PB674300121	PB67-43001-21
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) PB67-43001-21 batch: <i>41370</i> <i>mf 08-10-24</i>		
5.0	PB674300123	PB67-43001-23
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) PB67-43001-23 batch: <i>41371</i> <i>mf 08-10-24</i>		